

Date: Thursday, 15/03/2007 8:08:45 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER BLOCK
Job Number : 28517A	
Estimate Number : 10251	
P.O. Number : N/A	Part Number : D3193041
This Issue : 15/03/2007 S.O. No. : N/A	Drawing Number : D3193 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 13/09/2006 Type : LANDING GEAR	Drawing Revision : B
Previous Run : 25004A	Material : N/A
Written By : _____	Due Date : 02/10/2006 Qty: 8 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 05-11-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2500X03500	6061-T6 Bar 2.5" x 3.5"
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Comment: Qty.: 0.5156 f(s)/Unit Total: 4.1244 f(s)
 Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6B2.500x03.500)
 Identify for D3193-1
 Batch: _____

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: 3.500" x 2.500" x 5.900" long Bar

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1

2-Deburr and Tumble

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Date: Thursday, 15/03/2007 8:08:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BLOCK

Job Number: 28517A

Part Number: D3193041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(8X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-l

07/03/15

7.0 POWDER COATING POWDER COATING



(8X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

07/03/15

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

77

9.0 MS20426AD35 Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total: 128.0000 Each(s)

Pick:

Qty Part Number

Description Batch

16 MS20426AD35 7

Rivet M-4179

M17694

X

10.0 MS21073L4 NUTPLATE



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 8 MS21073L4

Nut Plate M18723

X

SB

07/03/21

(8)

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3193-041 as per Dwg D3193

SB

07/03/21

8

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

070321

Date: Thursday, 15/03/2007 8:08:46 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BLOCK

Job Number: 28517A

Part Number: D3193041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

15/03/22

Job Completion



U 07.03.22

Date: Wednesday, 9/13/2006 4:29:33 PM
 User: Kim Johnston

Process Sheet

*No second check
on this one.*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER BLOCK
 Job Number : 28517A
 Estimate Number : 10251
 P.O. Number :
 This Issue : 9/13/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : LANDING GEAR
 Previous Run : 25004A
 Part Number : D3193041
 Drawing Number : D3193 REV C *06.09.22*
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 10/2/2006 Qty: 8 Um: Each
 Written By : *06.09.14*
 Checked & Approved By :
 Comment : Est Rev:A New Issue 05-11-05 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2500X03500 6061-T6 Bar 2.5" x 3.5"



Comment: Qty.: 0.5156 f(s)/Unit Total : 4.1244 f(s)

Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8)

(M6061T6B2.500x03.500)

Identify for D3193-1

Batch: *M14805*

1 x M19067

8F 07/03/13

mk 06/09/22

8

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 3.500" x 2.500" x 5.900" long Bar

8F 07/03/13

mk 06/09/22

8

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1

2-Deburr and Tumble

8F/J.F 07/03/13

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3193-041 PAR #: NA Fault Category: Prod/Machined Parts NCR: Yes No DQA: NO Date: 07/03/22
 QA: N/C Closed: YES Date: 07.03.23

NCR: <u>28517A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/13	3.0	Origin was off on the the Hole position when the part was put back into the machine to open up the holes. Holes are oval. Opera for error.	<u>AS1042</u>	5 <u>THRS</u> Scrap: destroy; replace. Ensure hole gets opened to proper sizes and origin is correct.	<u>J.F</u> 07/03/13	<u>0703.13.</u>	<u>AS1042</u>	<u>06.03.13</u>
		i tool was O.D. was changed due to sharpening.						

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:29:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BLOCK

Job Number: 28517A

Part Number: D3193041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

MS20426AD35

Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Pick:

Qty Part Number

Description Batch

16 MS20426AD3-5

Rivet _____

8.0

MS21073L4

NUTPLATE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description Batch

8 MS21073L4

Nut Plate _____

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3193-041 as per Dwg D3193

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

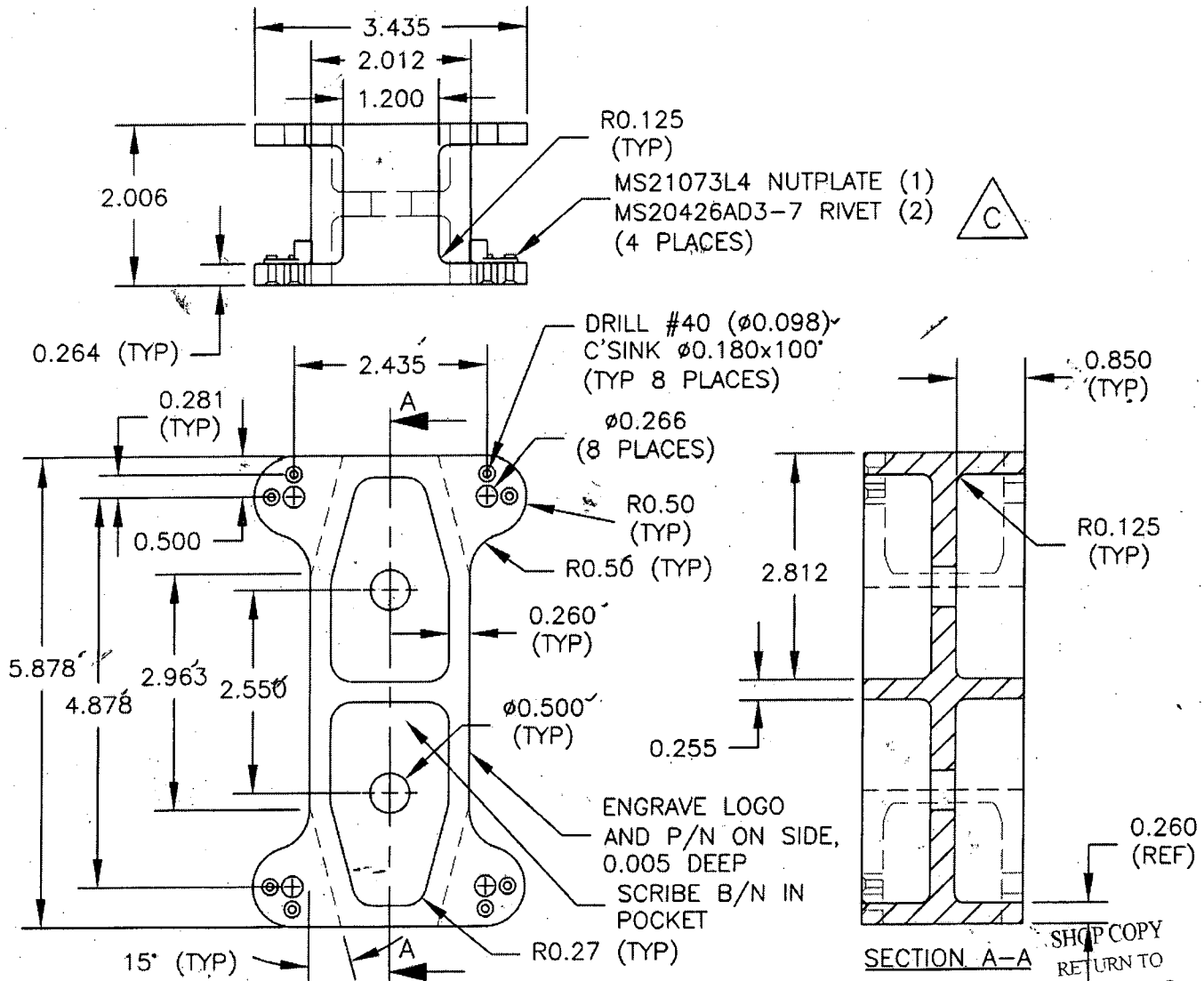
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY R	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED H	DRAWING NO. D3193	REV. C SHEET 1 OF 1
DATE 05.09.29	TITLE SUPPORT BRACKET ASSEMBLY		SCALE 1:2
A	03.06.09	NEW ISSUE	
B	03.12.22	MANUFACTURED BY DART	
C	05.09.29	MS20426AD3-7 WAS MS20426AD3-5	

RELEASED
05.09.30



D3193-041 SUPPORT BRACKET ASSEMBLY (D3193-1 SUPPORT BRACKET)

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-225/8 OR QQ-A-200/8)
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order: 29517 A
Description: SPACER Block		Part Number: D3193041
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 5.878	± .010	5.880	✓			
B 4.878	± .010	4.881	✓			
C 2.963	± .010	2.963	✓			
D 2.550	± .010	2.551	✓			
E 2.435	± .010	2.435	✓			
F 0.281	± .010	.282	✓			
G 0.260	± .010	.262	✓			
H 0.500	± .010	.498	✓			
I .098	± .005 ± .001	.099	✓			
J 2.5180 x 100°	± .010	.182	✓			
K .266	± .001 ± .001	.268	✓			
L R .270	± .010	.272	✓			
M 2.006	± .010	2.008	✓			
N 3.435	± .010	3.437	✓			
O 2.012	± .010	2.015	✓			
P 1.200	± .010	1.202	✓			
Q 2.125	± .010	2.125	✓			
R 0.850	± .010	.850	✓			
S R0.125	± 0.010	R.125	✓			
T 2.812	± 0.010	2.812	✓			
U .255	± .010	.252	✓			
V .260	± .010	.259	✓			
W						
X						
Y						

Measured by: J.B	Audited by: SD	Prototype Approval:	N/A
Date: 07/03/13	Date: 07.05.13	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved

